W	ork	Oi	der	ID	61230
77	UI N	\mathbf{v}	uu	\mathbf{I}	VIZJV

August 11, 2010 11:07:59 AM



Page 1

Item ID: D412-711-101 **Revision ID:**

Replacement Bubble Window

Start Date: 8/11/10 Required Date: 8/25/10 Start Qty: 1.00 Req'd Qty: 1.00



Date:_____

Cust Item ID:

Customer:

Reference:

Item Name:

Approvals:

Process Plan:

CX

Date: 10/8/11 Tooling:

Accept

SPC (Y/N):

Date:

Run

Start Stop

Stop

Setup Start



Sequence ID/ Work Center ID

Operation Description

Revision Nbr

Set Up/ **Run Hours** Tool ID

Tool # Plan Code Qty

Date:

Reject Accept Qty

Reject Number

der BG 10-8-27

Insp. Stamp

Draw Nbr

D412-711-101 Α

100

DC

Document Control

Memo

Photocopy bluefiles and create labels for PPP D412-711-101 Change 002

0.00

110

HandThermo

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Hand Finishing Thermoforming

Set up Machine as per folio FTA 077 and D711W program

120

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Cut Blanks to 36" by 39"

DR 10/08/25

W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Floatingi	
	1			-					<u></u>
Part No		PAR #:							
	Re	esolution:						Date: _	
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sign &		ication	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Sec	tion C	Chief Eng	QC Inspector
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Item	ID:
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D412-711-101

Accept



Date: ____

Setup Start



Revision ID: Item Name:

Replacement Bubble Window

Stop

Start Date:

8/11/10

Start Qty: 1.00 **Reg'd Qty:** 1.00

Operation

Description



Cust Item ID: Customer:

Required Date: 8/25/10 Reference:

A	nn	rav	'al	e:

Process Plan: _____ Date: ____

Tooling:

Set Up/

Run Hours

Date:

Run Start



Date: SPC (Y/N):

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Insp. Reject Number Stamp

Work Center ID 130

Thermoform

Sequence ID/

Thermoforming Machine

THERMOFORMING MACHINE

0.00 Memo

Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA Dwg. Rev. ____

Folio Rev.

140

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1) Check Surface finish for undesired marks, voids, dimples etc. 2) Check depth of bubble to ensure conformity to drawing tolerances.

150

QC8- Inspect parts - second check

0.00



Memo

0.00

Quality Control

W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PRO	DCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-									
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:		Date:	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMAN	ICE (NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	B Sign &	Verificat		Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Section	С	Chief Eng	QC Inspector
					:				
						1			

NOTE: Date & initial all entries

+:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 61230

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Page 3

Item ID: D412-711-101 **Revision ID:**

Replacement Bubble Window

8/11/10 **Start Date:** Required Date: 8/25/10

Start Qty: 1.00 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Tool ID

Setup Start

Stop

Reference:

Item Name:

Approvals:

Process Plan: _____ Date: ____

Operation

Description

QC: _____ Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Accept

Date:

Tool # Plan

Code

Date:

Start Run

Reject

Qty

Accept

Qty

Stop

Reject

A. 10/08/26

Number



10/08/26

Insp.

Stamp

Sequence ID/ Work Center ID

160

Hand Finishing Thermoforming

HandThermo

HAND FINISHING THERMOFORMING

QC2- Inspect parts off machine FAI/FAIB

Memo

blemishes

1) Trim off excess flange material

0.00

0.00

2) Buff out any light scratches or

3) Etch part number and batch number

170

Quality Control

Memo

0.00

0.00

1) VIsually inspect for clarity, and proper formation.

180

Quality Control

OC5- Inspect part completeness to step on W/O

0.00



Memo

1) VIsually inspect for clarity, and proper formation.

W/O:61	230	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/05/05	185	Pick Kit					10/01/27
	186	Remi change acy inspet kit for completeres Endoulos @					Solalon

Part No: <u>D412-711-101</u>	_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		·	WORK ORDI	ER NON-CONFORMANO	E (NCR)			
		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
				•				
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Work Order ID 61230

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Page 4

Item ID:

D412-711-101

Accept



Setup Start



Revision ID:

Item Name:

Replacement Bubble Window

Start Date:

Required Date: 8/25/10

8/11/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run

Start

Stop



Stop

Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

160L

0.00

0.00

Tool ID

Tool # Plan

Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CZ10/8/30

W/O:			W	ORK ORDER CHAN	IGES					
DATE	STEP	PRO	CEDURE CH	IANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									: 	
				•						
Part No	•	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o DQA	:	_ Date: _	
	R	esolution:	Disposit	ion:	QA: N	/C Clos	sed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORM	MANCE (NCR)				
DATE	STEP	Description of NC			ection B	lan 0	Verifica		Approval	Approval
DAIL	O I L	Section A	Initial Chief Eng	Action Description Chief Eng	n s	Sign & Date	Sectio	n C	Chief Eng	QC Inspector
-										

Picklist Print

August 11, 2010 11:07:59 AM

Work Order ID: 61230

Parent Item: D412-711-101

Parent Item Name: Replacement Bubble Window

I STRUM RUBU UTUK HICER KINI BEKKITALI I Terme ini bikan kini bikan kini kini kinik beri inibi kinik kinik kinik bikan kinik bilah kinik bilah kinik

Start Date: 8/11/10

Start Qty: 1.00

Required Date: 8/25/10

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 06-02-01

Manufacture in-house 10/06/28 DL

JLM

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236		Purchased	No				sf	65.0000	16	16			
		l											

Plexiglass G .236"

Location	Loc Qty	Loc Code
therm	65	
113571	17	
115096	48	

N) 10/08/26.

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			· · · · · · · · · · · · · · · · · · ·			· 			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DO	A:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C C	losed: _		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMAN	NCE (NCI	7)			
	I			Corrective Action Section	ı R				T
DATE	STED	Description of NC					ication	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	ication tion C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign	& Sec			
DATE	STEP	Description of NC Section A		Action Description	Sign	& Sec			
DATE	STEP	Description of NC Section A		Action Description	Sign	& Sec			
DATE	STEP	Description of NC Section A		Action Description	Sign	& Sec			
DATE	STEP	Description of NC Section A		Action Description	Sign	& Sec			
DATE	STEP	Description of NC Section A		Action Description	Sign	& Sec			
DATE	STEP	Description of NC Section A		Action Description	Sign	& Sec			
DATE	STEP	Description of NC Section A		Action Description	Sign	& Sec			

DART AEROSPACE LTD	Work Order:	6/230	
Description: 412 Baleble Window.	Part Number:	B412-711-101	
Inspection Dwg:4/2-71/ ~lg/Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than"	レ			
Shape Definition	-			
Texture Retention	V			
Material imperfections such as bumps, cracks, voids, scratching	•			
Measured by:]		Date:	10/08/26

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.50"	MIN.	1,875"				
39"	REF	32,511	~			
3/"	REF	31,0"	<u> </u>			
0.090"	MIN	0,099				
0.670"	MIN	0.085	~			
0.05011	MIN	0.075"	V			
			l '			

Measured by:	Date: 10 /08/26
Audited by:	Date: 10/08/27
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
В	10.04.14	Added preliminary approval	KJ	

